

Work Order ID 78922

78922

Page 1

January-17-12 9:01:55 AM

Item ID: D2731-7 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Mounting Lug
 Start Date: 17/01/2012 Start Qty: 80.00 ***80*** Cust Item ID:
 Required Date: 31/01/2012 Req'd Qty: 80.00 ***80*** Customer:
 Reference:

Approvals: Process Plan: M.C.5 Date: 12/01/17 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2731	Rev C								

100 BAND SAW 0.00
100
 Bandsaw Memo 0.00 CL 12/01/18
 Jeaspa Bandsaw Cut D2423 extrusion to .82" Batch _____

cut @ meters

110 HAAS CNC VERTICAL MACHINING #1 0.00
110
 HAAS CNC vertical machine #1 Memo 0.00 CL 12/01/18 80
 1-Machine as per folio FA930
 DWG REV: _____
 FOLIO REV: _____

P/O: 15923

2-Check for crack while loading into the machine

issue P/O to meters
machine as per drawing D2731 REV.C

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120 QC *120* QC Quality Control	QC2-Inspect parts off machine FAI/FAIB Memo rec'd + inspect for transit damage attached c of c to W10	0.00 0.00						11/4/3/8	(80)
--	--	------------------	--	--	--	--	--	----------	------

130 *130* QC Quality Control	QC2-Inspect parts - second check Memo	0.00 0.00						counts (x80)	
--	--	------------------	--	--	--	--	--	-----------------	--

140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							80x of m. 12/03/12
---	---	------------------	--	--	--	--	--	--	--------------------

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
150									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <u>3h15</u> OVEN TEMPERATURE: <u>320°F</u> FINISH TIME: <u>3h45</u>								
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location ST 469	0.00							
170									
Packaging	Memo	0.00							
Packaging									

80 QB/20 12/03/15

80X 2 M/L 13/03/15

80X SP 12-03-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

MLJ 12/03/20

12-03-20

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NOTE: Date & initial all entries

Picklist Print

January-17-12 9:01:58 AM

Page 1

Work Order ID: 78922

78922

Parent Item: D2731-7

D2731-7

Parent Item Name: Mounting Lug

Start Date: 17/01/2012

Required Date: 31/01/2012

Start Qty: 80.00

Required Qty: 80.00

Comments: IPP D00.05.19Added inspect level 8, removed P/O powder coatingEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2731-7P		Purchased	No			100	Each	0.0000	1	80			
D2731-7P									**				
LUG													
D2423		Manufactured	No			110	f	401.5000	0.0683	5.751579			
D2423									**				
Lug Extrusion													

1/23/12 (80)

CL 12/01/12

Location

Loc Qty

Loc Code

MAT006

401.5

43722

161.5

45800

1

68331

239

5.75

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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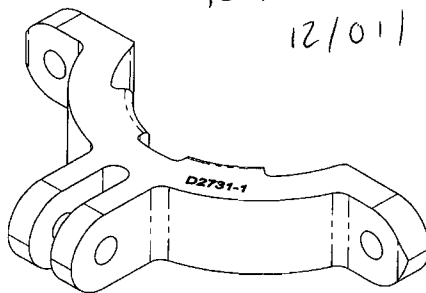
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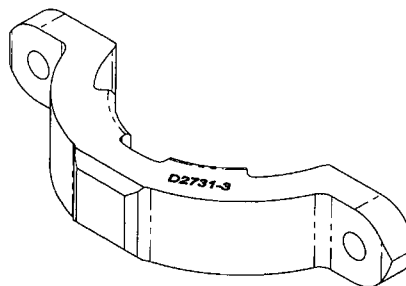
NOTE: Date & initial all entries

SHOP
RETURN
ENGINEER
UNCONTROLLED COPY
SUBJECT TO CHANGE

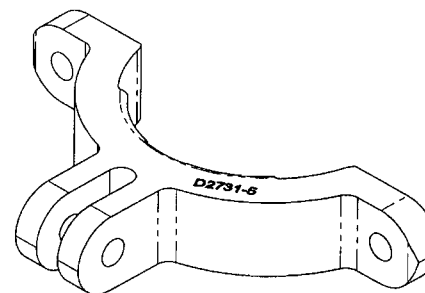
NO. 78922 M.C.J.
12/01/17



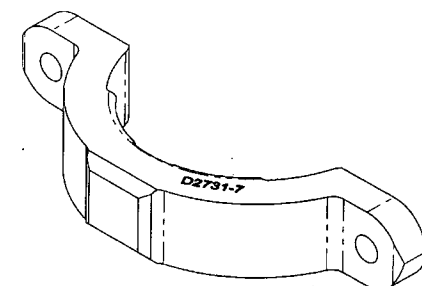
D2731-1 MOUNTING LUG



D2731-3 MOUNTING LUG



D2731-5 MOUNTING LUG



D2731-7 MOUNTING LUG

DEO ATTACHED
RELEASED
07/02/25/14

NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005 .
- 7) WEIGHT: -1: 0.17 lbs
-3: 0.15 lbs
-5: 0.16 lbs
-7: 0.14 lbs

C	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A, B-B, C-C & D-D FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.19
B	REVISED DIMENSIONS	KE	99.07.06
A	NEW ISSUE	KE	98.05.13
REV.	DESCRIPTION	BY	DATE
DESIGN	KE	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2731	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	09.01.19	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMPARATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

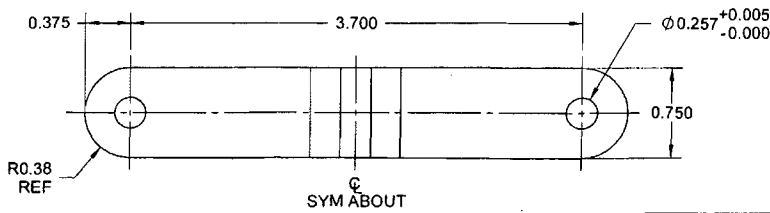
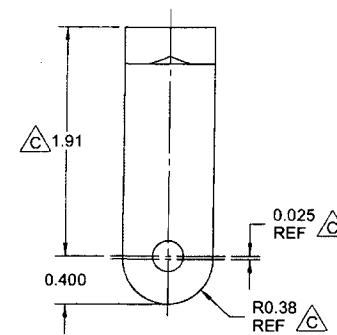
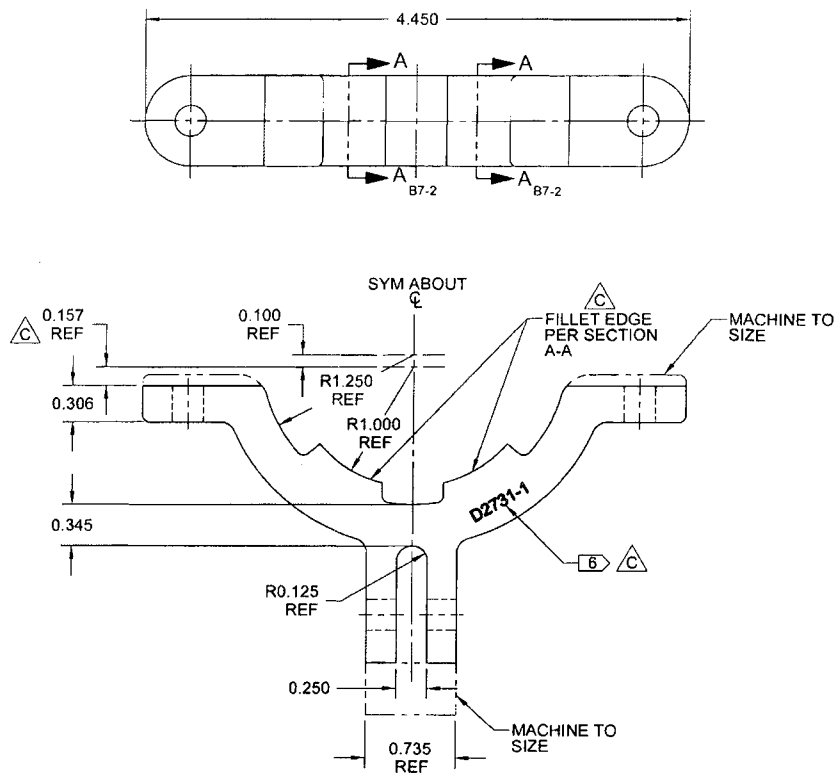
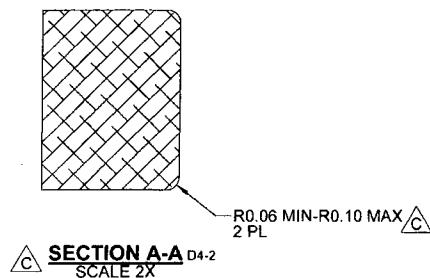
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



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78922



D2731-1 MOUNTING LUG

DEO ATTACHED
RELEASED
29/06/25/44

DESIGN	KE	DART AEROSPACE USA, INC.	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2731	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	09.01.19	COPYRIGHT © 1990 BY DART AEROSPACE USA, INC.	
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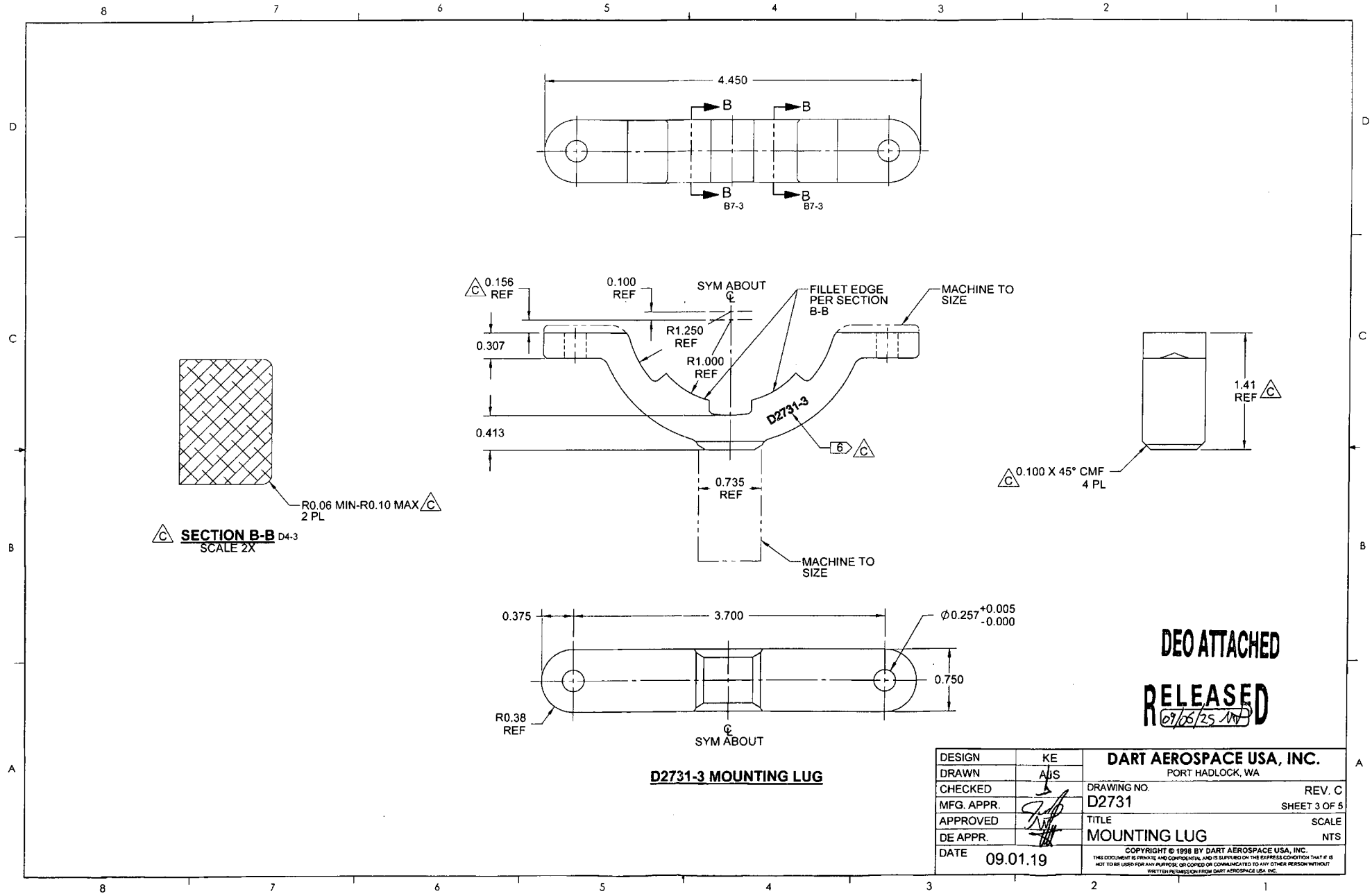
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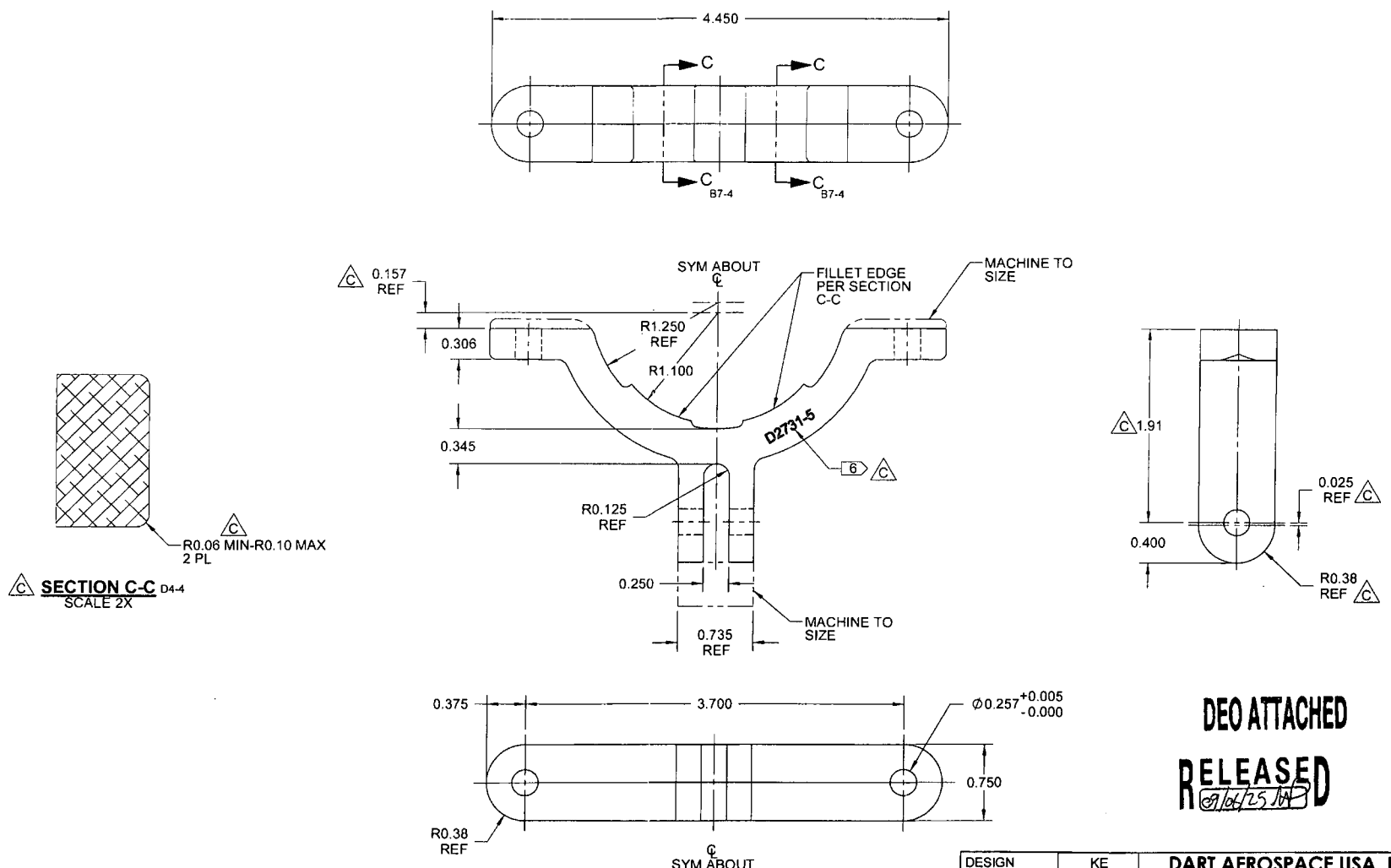
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78922



DEO ATTACHED
RELEASED
09/04/25

D2731-5 MOUNTING LUG

DESIGN	KE	DART AEROSPACE USA, INC.	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2731	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
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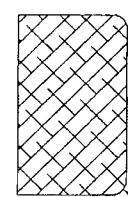
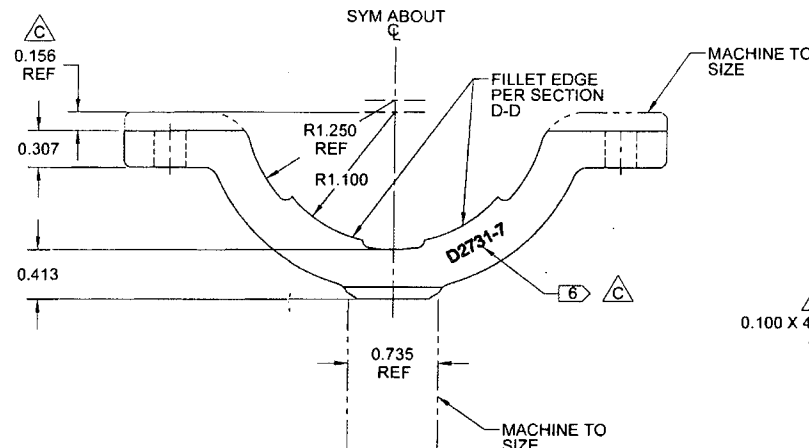
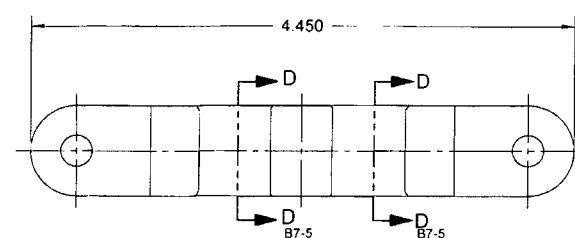
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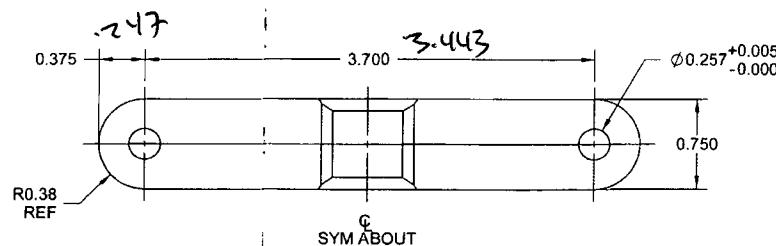
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78922

60



SECTION D-D D4-5
SCALE 2X



D2731-7 MOUNTING LUG

DEO ATTACHED
RELEASED
09/06/25/11

DESIGN	KE	DART AEROSPACE USA, INC.	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2731	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	09.01.19	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT NOTICE FROM ISSUING FROM DART AEROSPACE USA, INC.</small>	

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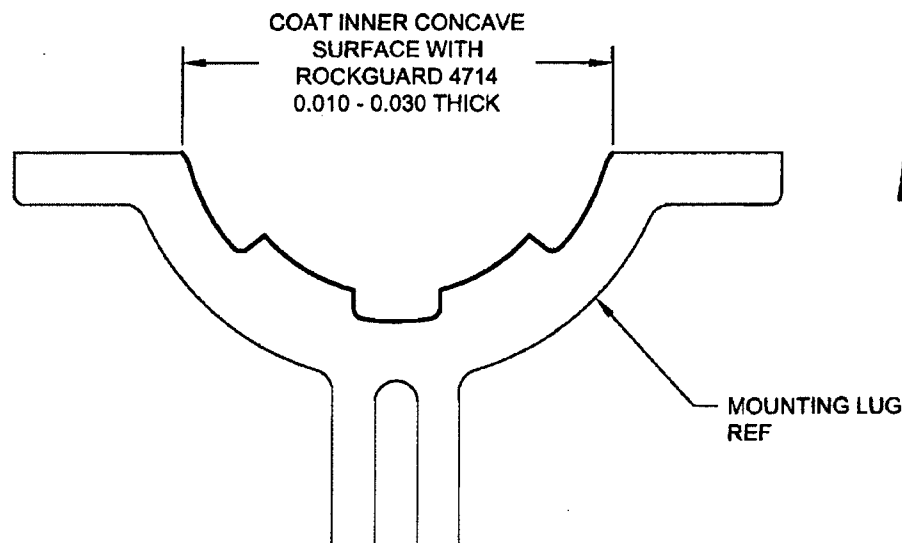
DRAWING NO. D2731	TITLE MOUNTING LUG	REV. C	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D2731-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN JP	CHECKED SC	MFG. APPR. [Signature]		APPROVED [Signature]		DE APPR. [Signature]	
DATE 11.05.02	DATE 11.05.09	DATE 11.05.09		DATE 11.05.09		DATE 11.05.09	

PURPOSE

ADD D2731-xRG OPTION

CHANGE

D2731-xRG MOUNTING LUGS ARE IDENTICAL TO D2731-x MOUNTING LUGS, HOWEVER AFTER FINISH, COAT INNER CONCAVE SURFACE WITH "PLUS ONE ROCKGUARD 4714" AS SHOWN BELOW.



RELEASED
2011-05-24
[Signature]

D2731-1RG MOUNTING LUG (SHOWN)
D2731-3RG/-5RG/-7RG MOUNTING LUGS (SIMILAR)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 18466
Date: Mar 08, 2012
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 15923	Sold By: Dewar, Eric
Shipped By: our truck	Ship Date:

Description		Unit	Ordered quantity	Shipped quantity	Backorder quantity
D3394-3	Lug as per drawing D 3394 REV.B B78921	Each	80		
D2731-7	LUG as per drawing D2731 REV.C B78922	Each	80	80	
<div>The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.</div>					
Received by _____			Thank you for your order!		



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

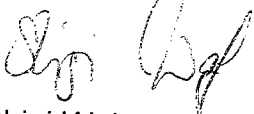
same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
80	D2731-7	Lug	5.2/13/09 15923

MATERIAL: supplied by DART B68331

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz

Vankleek Hill, March 8, 2012